

split

Work Order ID 111065

January-15-14 1:54:01 PM

\*111065\*

Page.1

Item ID: D212-722-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Avionics Riser Console

Start Date: 1/08/14 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 1/08/14 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-01-15 Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3363	Rev C
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100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D212-722-011 CHG003

DAS  
27  
9-89

14/3/26

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360  
Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall

2-Cut (1) D3361-1 to length as per Dwg D3361

Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr

5x

DAS  
36  
9-89  
14/23/06

January-15-14 1:54:01 PM

**\*1 1 1 065\***

Page 2

**\*N900040100\***

**Setup Start \*NS1\***

Stop \*NS2\*

**Start Date:** 1/08/14      **Start Qty:** 6.00      **\*6\***

**Cust Item ID:**

**Required Date:** 1/08/14      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	Chemical Conversion Coat per QSI005 4.1	0.00
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**\*120\***

**HandFinish**

<b>Memo</b>	0.00
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## Hand Finishing

130	QC7-Inspect Chemical Conversion Coat	0.00
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**\*130\***

QC

<b>Memo</b>	0.00
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## Quality Control

5 76143.7

5x \_\_\_\_\_ 14/03/2015  
36  
2-8

**Work Order ID 111065**

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**\*111065\***

Page 3

Item ID: D212-722-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Avionics Riser Console  
 Start Date: 1/08/14 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 1/08/14 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140	Small Fab	0.00							
<b>*140*</b>	Small Fab					5x			14/23/10
Small Fab	Memo	0.00							
Small Fab	1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rai 1***Mount Dzus Rails to DT8957 (Radio) and transfer drill into console.****								
	2-Rivet D3360-1/-3/-5 & D3361-1 & D3362-1 as per Dwg D3363								
	Identify as D3363-041								
	ATTN: INSTALL D3362-1, AND MAKE SURE THE RADIO THAT IS INSTALLED AT THIS PLACE FITS PRIOR TO CONTINUING TO MAKE HOLES.								

150	QC5- Inspect part completeness to step on W/O	0.00							
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<b>*150*</b>	QC								
Quality Control	Memo	0.00							

DAS  
27  
9-89  
14/3/10

DAS  
36  
9-89

S



# Work Order ID 111065

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**\*111065\***

Page 4

Item ID: D212-722-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Avionics Riser Console  
 Start Date: 1/08/14 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 1/08/14 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Pick Kit	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	Packaging	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212-722-011								

MAR 26 2014

6

100

06  
9-89

DAS  
27  
9-89

14/3/26

S

MAR 26 2014

AS

DAS  
06  
9-89

LOC 030



Work Order ID 111065

\*111065\*

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January-15-14 1:54:01 PM

Item ID: D212-722-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Avionics Riser Console

Start Date: 1/08/14 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 1/08/14 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

0.00

Quality Control

PL 14-03-26





# Picklist Print

January-15-14 1:54:04 PM

Page 1

Work Order ID: 111065

**\*111065\***

Parent Item: D212-722-011

**\*D212-722-011\***

Parent Item Name: Avionics Riser Console

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:B05.04.11Now made at DartKJ/JLM  
IPP Rev:C 07-06-09 Holes now Transfer drilled JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PFSC35-38A <b>*PFSC35-38A*</b> Dzus 1/4 Turn Fastener		Purchased	No			100	Each	12.0000	8	48		DAS 28 9-89	14-03-25
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST391				12		128546 (44x)			
				113856				12		4			
M6063T5A0.750W.063 <b>*M6063T5A0 750W 063*</b> Angle6063T5 .750 X.750 X.063w		Purchased	No			110	f	35.1600	6.9	44		DAS 36 9-89	14/03/05
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT006				35.16					
				124572				6.66					
				M126166				28.5					
M6063T5C.75X.75W.1 25 <b>*M6063T5C 75X 75W 125*</b> 6063 CHANNEL.750 X.750 X.125w		Purchased	No			110	f	10.0000	0.829	5		DAS 36 9-89	14/03/05
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT007				10		5			
				112040				10					
D3363-1 <b>*D3363-1*</b> Console		Manufactured	No			140	Each	0.0000	1	6		DAS 36 9-89	14/03/05

B 109571



# Picklist Print

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Page 2

Work Order ID: 111065

**\*111065\***

Parent Item: D212-722-011

**\*D212-722-011\***

Parent Item Name: Avionics Riser Console

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 6.00

Required Qty: 6.00

MS20426AD4-5 Purchased No 140 Each 1,736.000 44 264

**\*MS20426AD4-5\***

RIVET

**\*\***

DAS  
36  
9-89

14/03/10

Location

Loc Qty

ST334

1736

6874

736

m125807

1000

PR35-1 Purchased No 140 f

**\*PR35-1\***

DZUS FASTENER RAIL

**\*\***

DAS  
36  
9-89

14/03/08

Location

Loc Qty

Mezz

11.8344

107913

3.5

114504

8.3344

MS20426AD4-6 Purchased No 170 Each 3,102.000 9 54

**\*MS20426AD4-6\***

Rivet

**\*\***

DAS  
36  
9-89

14/03/10

Location

Loc Qty

GA

1582

m126474

1582

ST334

1520

124392

1520

Loc Code

220

Loc Code

1.6665

Loc Code

45

January-15-14 1:54:04 PM

Shop Packet Print

Page 2



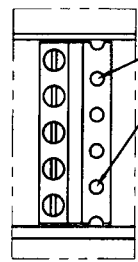
111065  
MLJ  
14-01-10



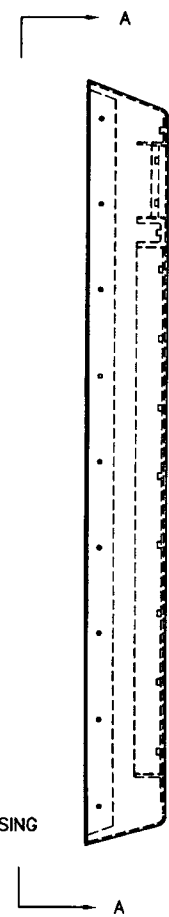
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
041	041		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
15	off	D3363	
DATE	TITLE	SCALE	
07.01.26	CONSOLE ASSEMBLY	1:5	
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT	

RELEASED  
07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (#0.225 X 100") FROM TOP SIDE OF CONSOLE



DETAIL C  
(SCALE 1:2)



C'SINK THIS SIDE (REF)

INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

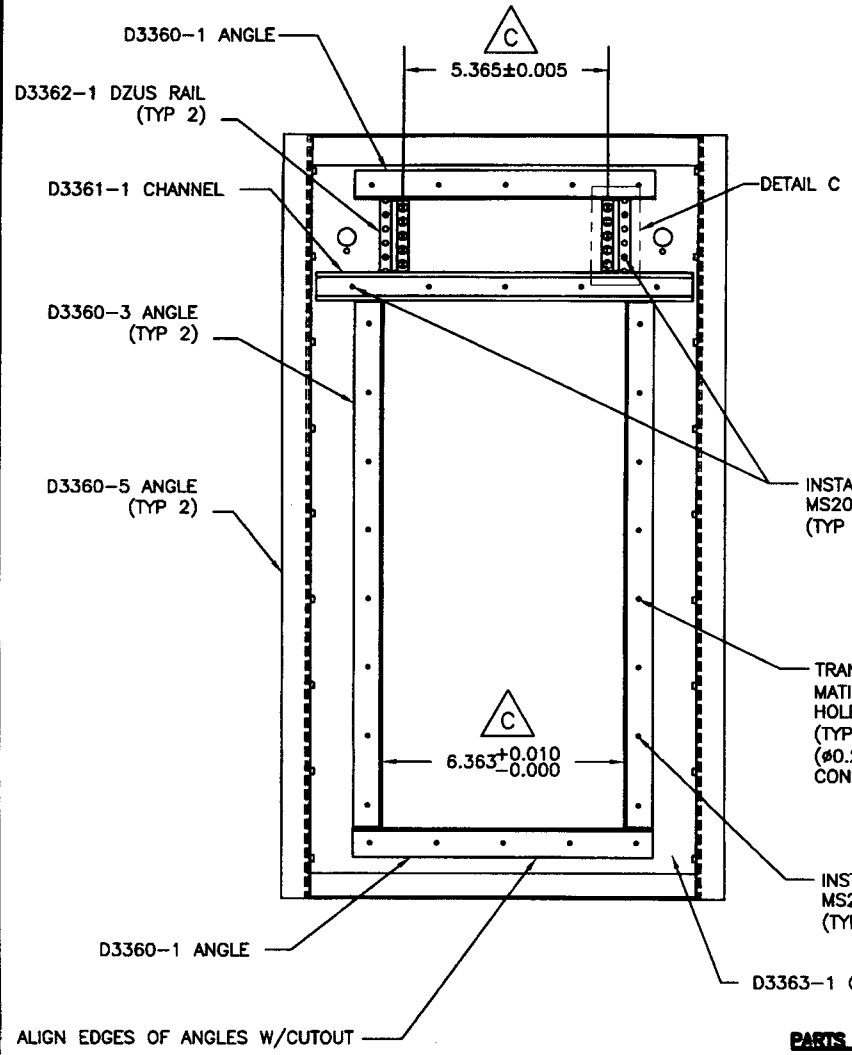
TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (#0.225 X 100") FROM CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

**PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY**

QTY	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET



**VIEW A-A FROM UNDER CONSOLE ASSEMBLY**

**D3363-041 CONSOLE ASSEMBLY**

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

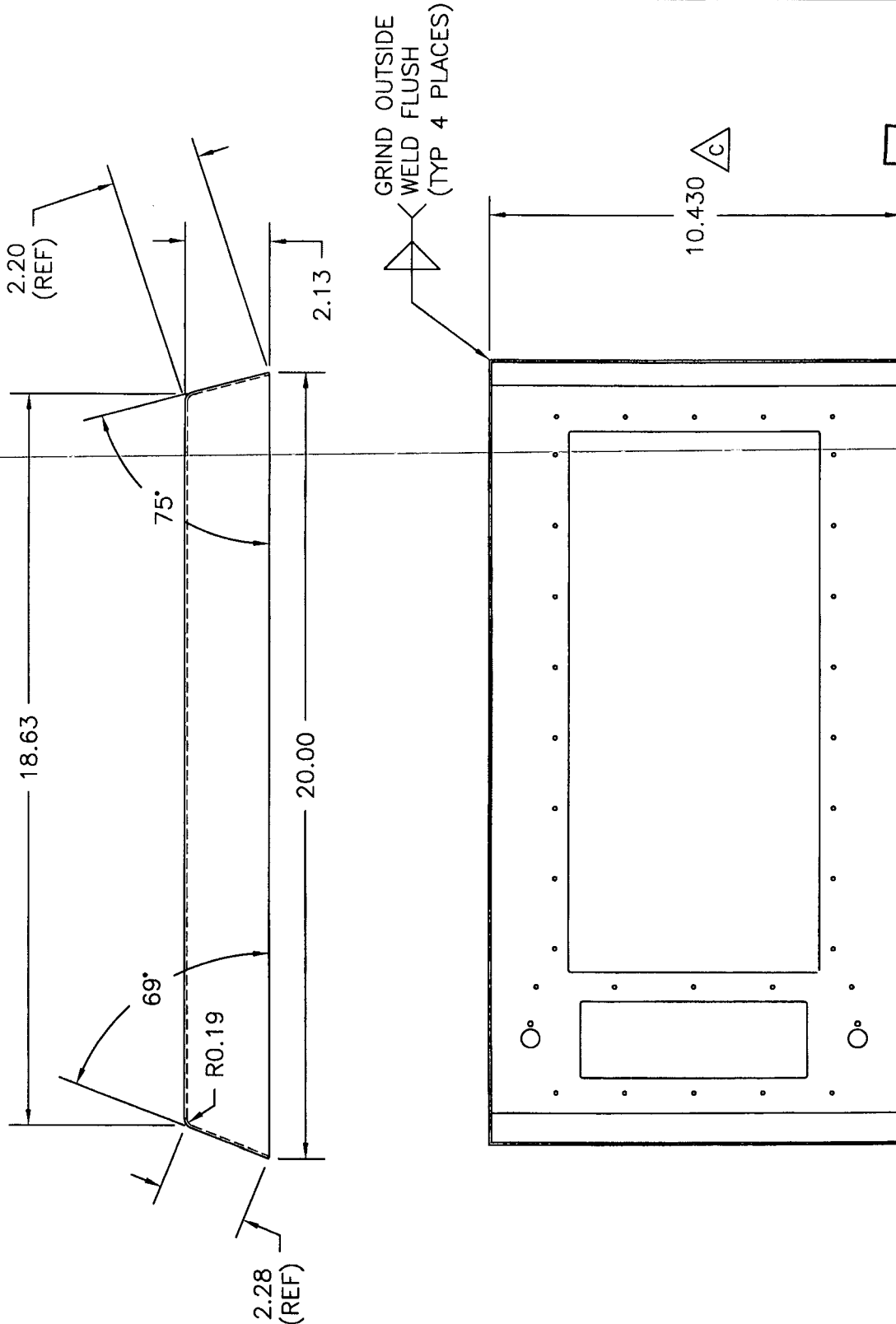
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CHECKED <i>JS</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



RELEASED  
07.06.04 *[Signature]*

- D3363-1 CONSOLE**
- 1) WELD PER DART QSI 004
  - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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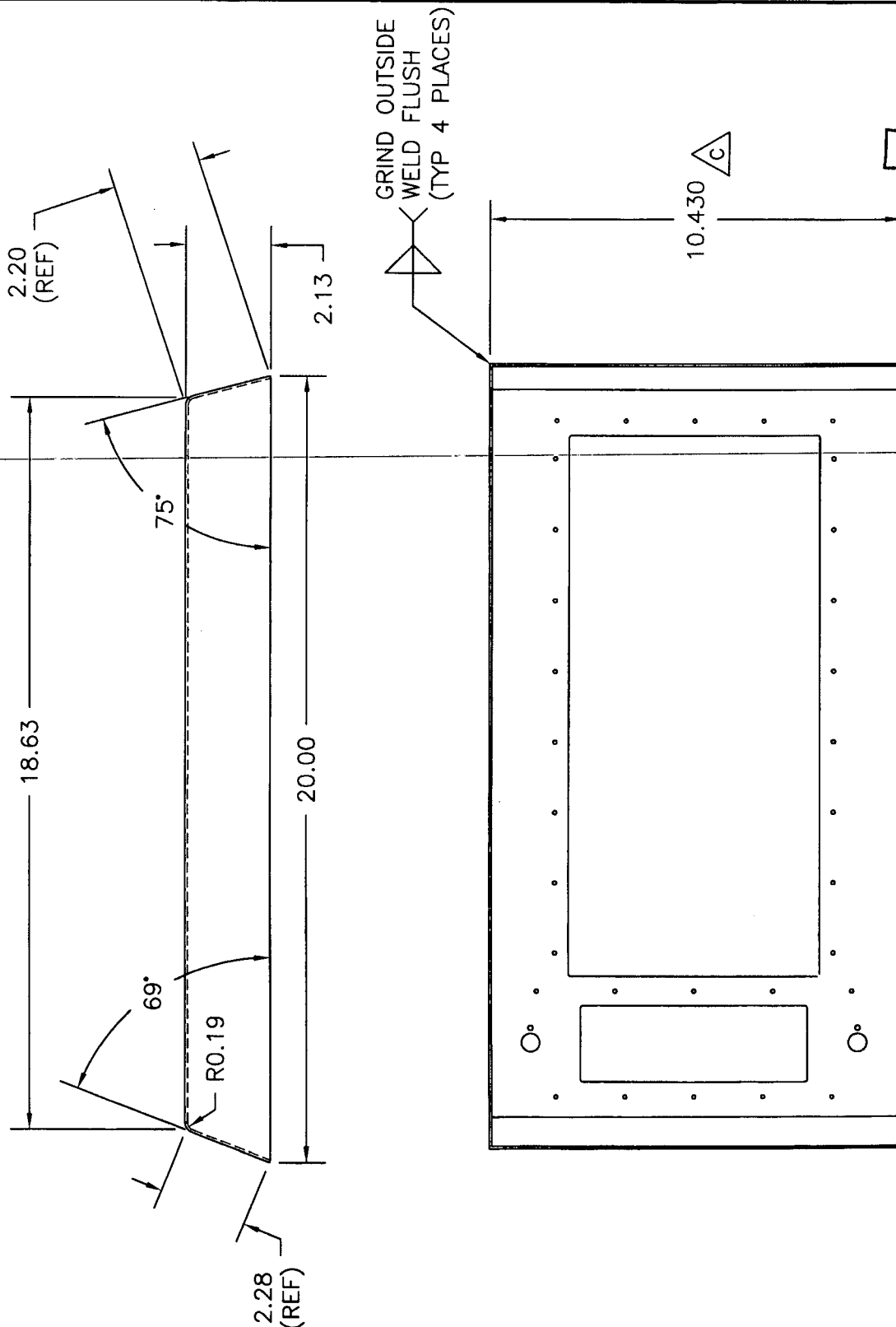
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CHECKED <i>JS</i>	APPROVED <i>JS</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



**D3363-1 BEND DETAIL**

(MAKE FROM D3363-1F FLAT PATTERN)

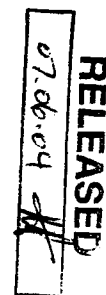
**D3363-1 CONSOLE**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED	3	APPROVED	[Signature]	DRAWING NO.	REV. C
				D3363	SHEET 3 OF 3
DATE				TITLE	SCALE
07.01.26				CONSOLE ASSEMBLY	1:6



1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) PART IS SYMMETRICAL ABOUT CENTERLINE



**REFERENCE****4.0 WEIGHT AND BALANCE**

The following weight and balance information does not include the installation of any equipment in the D212-722-011 Avionics Riser Console Assembly.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
<b>D212-722-011</b> <i>Avionics Riser Console</i>	2.3 lb 1.1 kg	0 in 0 m	0 lb-in 0 kg-m	37 in 0.9 m	85.1 lb-in 1.0 kg-m

**5.0 PARTS LIST**

Qty – 011	Part Number	Description
X	D212-722-011	AVIONICS RISER CONSOLE
1	D3363-041	CONSOLE ASSEMBLY
8	PESC35-38A	DZUS FASTENERS
REF	D1038-58	FASTENER RAIL
REF	D1038-58B	FASTENER RAIL, BLACK
REF	PR35	DZUS RAIL

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Revision: **A**

Date: 04.12.01

Work Order ID 111065

\*111065\*

Page 1

January-15-14 1:54:01 PM

Item ID: D212-722-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Avionics Riser Console

Start Date: 1/08/14

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 1/08/14

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan: MJS

Date: 14-01-15 Tooling:

Date:

Stop \*NR2\*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3363	Rev C								
100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D212-722-011 CHG003								
110	Small Fab	0.00							
*110*									
Small Fab	Memo	0.00							
Small Fab	1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360 Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall								
	2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall								
	3-Deburr								

MJS 14-03-11

5x 14/23/06 DAS 36 9-89

